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D3296-3
Job Sheet 187244



Part No: D3296-3

Job Qty: 10 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:E Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		12/13/18	0.04	0.80	Waterjet - Flow		5C 18/12/19 DAS
120	QC	10 pcs		12/13/18	0.00	0.00	QC8		DEC 21 2018 68
130	Small Fab	10 pcs		12/13/18	0.00	0.00	Small Fab-3		9-89
140	HandFinish	10 pcs		12/13/18	0.00	0.54	HandFinish1		D.R 18/12/2019 DAS
150	QC	10 pcs		12/13/18	0.00	0.00	QC7-2		JAN 02 2019 63
160	Packaging	10 pcs		12/13/18	0.00	0.00	Packaging3	5.494	JAN 03 2019 89
170	QC21-SA	10 Ea		12/13/18	0.00	0.00	QC21		21 JAN 03 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	6.5320 sf (.6532 ea)	100-Waterjet - Flow - 1	5029837

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	7	70	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.030inches ± 0.030	5.060 5.000		
2	Door Panel	0.060inches ± 0.010	0.070 0.050		
3	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128		
4	Door Panel	17.000inches ± 0.030	17.030 16.970		
5	Door Panel	16.400inches ± 0.005	16.405 16.395		
6	Door Panel	0.300inches ± 0.010	0.310 0.290		
7	Door Panel	0.300inches ± 0.010	0.310 0.290		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

8	Door Panel	1.000inches + 0.030 - 0.010	1.030 0.990
9	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053

Plex 11/29/18 10:01 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date : _____		_____		MRB (QSI042) _____	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 12/19/18 DART AEROSPACE Container No: S138924 Part: D3296-3 Job No: 187244 Serial No/Batch: S138924 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's _____					